

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.21**WELDING WITNESS REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WWR-000218**Date Inspected:** 24-May-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**Location:** Shanghai, China

Witness: **Procedure Qualification Record**
 Welding **NDT**

Welder Qualification **Fracture Critical**
Mechanical Testing, describe:

Index Lot #: B72-035-07**Witness Lot #:****Bridge No:** 34-0006**Component:** Bid: 52,55 Tower & Girder**Welder:** Zhu Hai Ping**ID #:** N/A**Joint Description:** B-U2a

N/A

WPS ID #: PWPS-B-T-3211

N/A

Base Metal: A709M-HPS-485W

N/A

PQR ID #: HP200776-1

N/A

Thickness: 75 millimeters

N/A

Process: SMAW

N/A

Electrode Spec/Class: AWS A5.5/ E9018M MR

N/A

Positions: Flat 1G

N/A

Backing Material: A709M-HPS-485W

N/A

CWI: Wei Huang

N/A

Average Amps: 257.1

N/A

AWS Code: AWS D1.5 2002

N/A

Average Volts: 22.4

N/A

Applicable Sec: Paragraph 5.13

N/A

Travel Speed: 118.2 millimeters/minute

N/A

Heat Input: 2.93 KiloJoules/millimeter

N/A

Preheat: 195.4C

N/A

Summary of Items Observed:

Caltrans Quality Assurance (QA) Inspectors Bruce Berger, Mike Hessler and Alfredo Acuna observed the welding variables and practices during welding of this procedure qualification test plate. With respect to the paragraph on "Shop Welding" in the special provisions there was no obvious air movement monitored during the running of this test. This PQR appears to be in visual compliance with the code and specification.

Summary of Conversations:

A conversation was held with ZPMC Quality Control Inspector (QC), Wei Huang. In the conversation Wei stated that due the time of day the final visual inspection would be held tomorrow morning after the Procedure Qualification Test piece cooled down to ambient temperature.

Observed welding,testing or results:

is in general conformance with the contract requirements.

is not in conformance with the contract requirements.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

WELDING WITNESS REPORT

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Inspected By:	Berger, Bruce	Quality Assurance Inspector
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Reviewed By:	McClary, David	QA Reviewer
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